

Work Order ID 130966

130966

Page 1

Item ID: D4777-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rod End Bearing

Stop *NS2*

Start Date: 3/26/15 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 150330 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4777	A

100	PURCHASING	0.00
-----	------------	------

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 27963

Purchase Part Number: 59915K274 Supplier: Mc Master Carr
Certificate of conformity is required

CK 15/03/31 2

110	Receive & Inspect for Damage & Mat'l Certs	0.00
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110

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

PK 6015-04-7

120	QC6- Inspect dimensions to drawing	0.00
-----	------------------------------------	------

120

QC

Memo

0.00

Quality Control

(8)

DAS
9-89 38
9-89

APR 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130966***130966***

Page 2

Item ID: D4777-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rod End Bearing

Stop

NS2

Start Date: 3/26/15 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/26/15 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location St 127

0.00

130

Packaging

Memo

0.00

Packaging

8 DAS
27
8-89

APR 07 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 15040715-4-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:32:31 PM

Page 1

Work Order ID: 130966

130966

Parent Item: D4777-1

D4777-1

Parent Item Name: Rod End Bearing

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
59915K274 *59915K274* Rod End Bearing		Purchased	No			110	Each	0.0000	1	8			

**

8X SP15-04-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

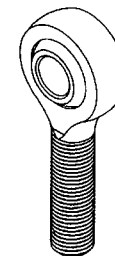
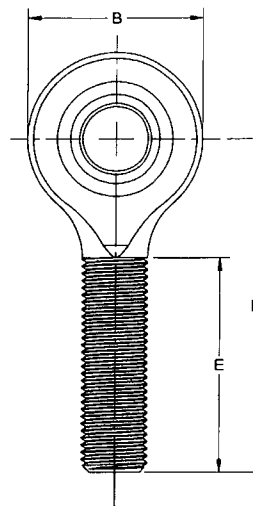
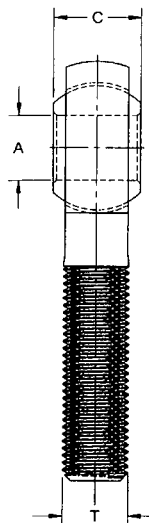
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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SPECIFICATION CONTROL DRAWING



ROD END BEARING

130966 MJS
1503-30

DART P/N	HOUSING MATERIAL	A	B	C	D	E	T (THREAD SIZE)	SUGGESTED SUPPLIER	SUGGESTED SUPPLIER P/N
D4777-1	STAINLESS STEEL	Ø0.38	1.00	0.500	1.94	1.25	3/8-24 (RIGHT HAND)	MC MASTER CARR	59915K274

RELEASED
2013-08-14

A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.08.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4777**
REV. A
SHEET 1 OF 1
TITLE **ROD END BEARING**
SCALE **NTS**
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SPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER**Purchase Order ID PO27963****Purchase Order Date** 3/31/2015**PO Print Date** 3/31/2015**Page Number** 2 of 4**Order From :**

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name**Vendor Phone**

330 995 5500

Ship To Contact**Ship To Phone****Ship Via:**

FedEx Overnight collect

Ship Acct:**Buyer**

Chantal Lavoie

Customer POID**Customer Tax #**

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

3	59915K274	Rod End Bearing	4/1/2015	8.00	✓	\$17.14	\$137.12	✓
			Yes	Each				
			4/1/2015					

AS PER DWG D4777 REV. A
B130966

SP15-04-2

Line Total: \$137.12

4	91525A120	washer	4/1/2015	50.00		\$0.27	\$13.32	
			Yes	Each				
			4/1/2015					

AS PER DWG D3456 REV. A
B130974

Line Total: \$13.32

5	95606A170	Washer	4/1/2015	100.00		\$0.09	\$8.60	
			Yes	Each				
			4/1/2015					

AS PER DWG D3631 REV. A
B131026

Line Total: \$8.60**Note:**

3/31/2015



Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Deliver To Luc

Purchase Order
PO27963
Order Placed By
Chantal Lavoie

Page 1 of 1

03/31/2015

McMaster-Carr Number
1428983-01

Line	Product	Ordered	Shipped
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer	1 Each	1
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10	5 Packs	5
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	8 Each	8 ✓
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100	1 Pack	1
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick	40 Each	40
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long	1 Each	1
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity Your Part Number: 71400-40	4 Each	4
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc Your Part Number: 71400-40	4 Each	4

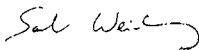
McMaster-Carr Supply Company 200 Aurora Industrial Pkwy Aurora, OH 44202-8087 USA Phone: 330-995-5500 Fax: 330-995-9600 E-Mail: cle.sales@mcmaster.com Employer Identification Number (EIN): 36-1458720		Invoice: 26682794 Purchase Order: PO27963 Release: McMaster-Carr Number: 1428983-01		ORIGINAL COMMERCIAL INVOICE CERTIFICATE OF ORIGIN	
Ultimate Destination: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Shipped: 31-Mar-2015 Shipper's Export Declaration (SED): NO EEI 30.36		FOB: ORIGIN	
Intermediate Consignee:		Bill To: Dart Aerospace Ltd 1270 Aberdeen St Hawkesbury ON K6A 1K7 Canada		Tax Number:	
Forwarding Agent:		Billing Attention: Shipping: Deliver To Luc Attention: Contact:			

Line	Description	Qty & Unit	Unit Price	Extension
1	8568K186 High-Strength Multipurpose Neoprene Rubber, 1/2" Thick, 12" X 24", 60A Durometer Country of Origin: United States Schedule B #: 400821 ECCN #: EAR99 NLR	1 EA	\$102.55	\$102.55
2	91343A100 Type 316 Stainless Steel Serrated-Flange Locknut, 1/4"-20 Thread, 19/32" Flange Diameter, 15/64" Overall HT., Packs of 10 Country of Origin: Taiwan Schedule B #: 731816 ECCN #: EAR99 NLR	5 PK	\$3.83	\$19.15
3	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	8 EA	\$17.14	\$137.12
4	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32

SP1504-2

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 21		Number of Packages: 1		Invoice Amounts:		Merchandise Amount: \$1,284.06	
Package Dimensions: 64 X 33 X 34 CM = .071 CUBIC M				Total (In USD):		\$1,284.06	
				Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days			
Authorized Signature: 		Date: 31-Mar-2015		Remit payment to: (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA		(by wire transfer) Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N	
Name: Sarah Weinberg		Title: Operations Mgr.		Page 1 of 2			

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Fax: 330-995-9600

Invoice: 26682794

Purchase Order: PO27963

Release:

McMaster-Carr Number: 1428983-01

ORIGINAL COMMERCIAL

INVOICE

CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
6	63215K34 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 3/8" ID, 13/16" OD, 13/32" Ball Thick Country of Origin: Peoples Republic of China Schedule B #: 848330 ECCN #: EAR99 NLR	40 EA	\$17.24	\$689.60
7	9198K16 Easy-to-Machine 303 Stainless Steel Rod, 5" Diameter, 3" Long Country of Origin: Sweden Schedule B #: 722211 ECCN #: EAR99 NLR	1 EA	\$154.08	\$154.08
8	19525T13 Nonmarking High-Temperature Caster, Swivel, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$23.53	\$94.12
9	19525T17 Nonmarking High-Temperature Caster, Rigid, 4" X 1-1/4" Brown Nylon Wheel, 300# Capacity, Deliver To Luc 71400-40 Country of Origin: Peoples Republic of China Schedule B #: 871690 ECCN #: EAR99 NLR	4 EA	\$16.38	\$65.52
	NOTE Tracking number(s) for this shipment: 633862298275			

Number of Packages: 1

Page 2 of 2